



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1611

Job Sheet 205053



Part No: 647.1611

Job Qty: 20 pcs

Part Name: Wiper Deflector, Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/27/19

Job Tracking No:

Due Date: 3/30/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEETS 3,4 IPP REV A NEW ISSUE VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs		3/30/20	0.00	0.02	Bandsaw - 1		ALA 20/03/20
110	HAAS 4 Axis - B4B	20 pcs		3/30/20	0.43	23.09	HAAS - 1 - B4B HAAS - 2 - B4B HAAS - 3 - B4B HAAS - 4 - B4B		20/03/20
120	QC 2	20 pcs		3/30/20	0.00	0.00	QC 2 - 1 QC 2 - 12 QC 2 - 14 QC 2 - 17 QC 2 - 19 QC 2 - 2 QC 2 - 20 QC 2 - 22 QC 2 - 23 QC 2 - 25 QC 2 - 32 QC 2 - 33 QC 2 - 35 QC 2 - 39 QC 2 - 4 QC 2 - 40 QC 2 - 44 QC 2 - 45 QC 2 - 48 QC 2 - 49 QC 2 - 50 QC 2 - 51 QC 2 - 52 QC 2 - 57 QC 2 - 62		125 20-03-22



Container No: S265501



Part: 647.1611

Job No: 205053

Serial No/Batch: S265501

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/22/20

					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130	QC 8	20 pcs	3/30/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	mm L 20/03/20
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140	Outsource - 4 - Anodize	20 pcs	3/30/20		ATG001-VC	5 2020-03-27
150	Packaging 2-1 - Receive - B4B	20 pcs	3/30/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	116 APR 15 2020
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 -	

					B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
155	QC 6	20 pcs	3/30/20	0.00 0.00	QC 6 - 9	DAS
					QC 6 - 68	81
					QC 6 - 61	9-89
					QC 6 - 40	
					QC 6 - 81	
180	Packaging 3-1 - Stock - B4B	20 pcs	3/30/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	✓
					Packaging 3 - 4 - B4B	DAS
					Packaging 3 - 5 - B4B	CCK09180
					Packaging 3 - 6 - B4B	APR 22 2020
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	

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					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
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					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
190	QC 21 - SA	20 ✓ pcs	3/30/20	0.00 0.00	QC 21 - SA - 21 ✓	clk 091
					QC 21 - SA - 70	DAS
					QC 21 - SA - 53	21 9-20

Part Op 100 - (Bandsaw) Cut Blanks at 6.00"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB287

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 46189

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
647.1611E	Wiper Deflector	10 ft (.5 ea)	100-Bandsaw - 1	S/43861
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	647.1611E	10	347	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wiper Deflector, Aft	0.320inches $\pm$ 0.010	0.330 0.310	.321	
2	Wiper Deflector, Aft	5.770inches $\pm$ 0.010	5.780 5.760	5.775	
3	Wiper Deflector, Aft	2.420inches $\pm$ 0.010	2.430 2.410	2.420	
4	Wiper Deflector, Aft	0.360inches $\pm$ 0.010	0.370 0.350	.360	
5	Wiper Deflector, Aft	1.560inches $\pm$ 0.010	1.570 1.550	1.556	
6	Wiper Deflector, Aft	0.404inches $\pm$ 0.005	0.409 0.399	.405	
7	Wiper Deflector, Aft	3.967inches $\pm$ 0.002	3.969 3.965	3.966	
8	Wiper Deflector, Aft	0.433inches $\pm$ 0.005	0.438 0.428	.433	Diameter
9	Wiper Deflector, Aft	0.146inches $\pm$ 0.005	0.151 0.141	.145	Depth
10	Wiper Deflector, Aft	0.217inches $\pm$ 0.005	0.222 0.216	.217	Diameter
11	Wiper Deflector, Aft	0.365inches $\pm$ 0.005	0.370 0.360	.364	
12	Wiper Deflector, Aft	1.385inches $\pm$ 0.002	1.387 1.383	1.386	
13	Wiper Deflector, Aft	2.160inches $\pm$ 0.010	2.170 2.150	2.160	
14	Wiper Deflector, Aft	0.350inches $\pm$ 0.010	0.360 0.340	.355	
15	Wiper Deflector, Aft	0.200inches $\pm$ 0.010	0.210 0.190	.200	
16	Wiper Deflector, Aft	0.944inches $\pm$ 0.005	0.949 0.939	.945	
17	Wiper Deflector, Aft	0.606inches $\pm$ 0.002	0.608 0.604	.606	
18	Wiper Deflector, Aft	0.381inches $\pm$ 0.002	0.383 0.379	.381	
19	Wiper Deflector, Aft	3.310inches $\pm$ 0.010	3.320 3.300	3.315	
20	Wiper Deflector, Aft	0.713inches $\pm$ 0.002	0.715 0.711	.713	
21	Wiper Deflector, Aft	1.445inches $\pm$ 0.002	1.447 1.443	1.445	
22	Wiper Deflector, Aft	0.540inches $\pm$ 0.010	0.550 0.530	.534	
23	Wiper Deflector, Aft	0.150inches $\pm$ 0.010	0.160 0.140	.152	Diameter
24	Wiper Deflector, Aft	62.700Degrees $\pm$ 0.500	63.200 62.200	62.8	Angle
25	Wiper Deflector, Aft	0.170inches $\pm$ 0.005	0.175 0.169	.170	Diameter
26	Wiper Deflector, Aft	0.200inches $\pm$ 0.010	0.210 0.190	.200	Radius
27	Wiper Deflector, Aft	4.880inches $\pm$ 0.010	4.890 4.870	4.875	
28	Wiper Deflector, Aft	3.890inches $\pm$ 0.010	3.900 3.880	3.892	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046189



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046189
PO Date: 3/27/20
Due Date: 4/13/20
Purchase Order Revision:
Revision Date:
Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197648	647.1912	647.1900 Rev N/C	Bracket LH : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O: Black Anodize as per Dwg 646.3800	Firmed X10	-	4/13/20	10 pcs	0 pcs	10 pcs	\$10.48/pcs	\$104.80
									APR 15 2020			
2	207950	RBEL135M-2905-101-09	RBEL135M-2905-101 Rev 9	Drive Pulley Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed X4	-	4/13/20	4 pcs	0 pcs	4 pcs	\$6.98/pcs	\$27.92
									APR 15 2020			
3	208136	C10-21-2	C10-21-2 Rev 2	Spring Cover -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed X20	-	4/13/20	20 pcs	0 pcs	20 pcs	\$6.98/pcs	\$139.60
									APR 15 2020			

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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046189



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	205064	647.7811	647.7800 Rev A	Bracket B : Various STC's Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	-	4/13/20	8 pcs	0 pcs	8 pcs	\$16.28/pcs	\$130.24
5	205063	647.7810	647.7800 Rev A	Bracket A : Various STC's Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	-	4/13/20	8 pcs	0 pcs	8 pcs	\$16.28/pcs	\$130.24
6	205053	647.1611	647.1600 Rev A	Wiper Deflector, Aft : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed <i>KR</i>	-	4/13/20	20 pcs	0 pcs	20 pcs	\$12.48/pcs	\$249.60
Grand Total:												\$782.40

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guerrin

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919986

Date: 14-Apr-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 647.1912 Bracket LH Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 122522 Job: 27240 PO: POHB046189		Rev: N/C Expiry Date: 05/21 Line: 1
4 ea	Part: RBEL135M-2905-101-09 Drive Pulley Anodize per MIL-A-8625F, Type II, Class1, Clear, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 27241 PO: POHB046189		Rev: 9 Line: 2
20 ea	Part: C10-21-2 Spring Cover Hard Black Anodize per MIL-A-8625F, Type 2, Class 2, Water Sealant Job: 27242 PO: POHB046189		Rev: 2 Line: 3
20 ea	Part: 647.1611 Wiper Deflector, Aft Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Batch/Lot#: 122522		Rev: A Expiry Date: 05/21
Made in Canada.			

no rush

no rush

no rush

no rush

RECEIVED
APR 14 2020
DART AEROSPACE LTD.

no rush

no rush

no rush

no rush

RECEIVED

APR 14 2020

DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919986

Date: 14-Apr-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Job: 27245 Line: 6 PO: POHB046189		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>APR 14 2020</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			